

Work Order ID 66230

February 8, 2011 8:43:12 AM



Page 1

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 2/08/11 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CY Date: 1/10/2/08 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3537	Rev C

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☒ Dwg Rev: C ☐ Prog Rev: C ☐ 2-

Deburr if necessary

B 11-2-15



110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-2-15

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/2/15



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Item Name: Wearpad

Start Date: 2/08/11 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8 ulostog

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 ulostog

Quality Control

(14)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

START TIME:

12:00

OVEN TEMPERATURE:

320°F FINISH TIME:

12:30

Powder Coating

M116128

(14X) M-1 4/05/06

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Item ID: D3537-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 2/08/11 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

14X 1 05 06

200



Packaging

Packaging

Identify as per dwg & Stock Location:

FP 17

0.00

Memo

0.00

14X 1 05 06

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/11

mf

11-05-06

Picklist Print

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Page 1

Work Order ID: 66230



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No..

100

sf

222.2800

0.149

1.882105



2.1
131-2-15

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

222.28

111323

0

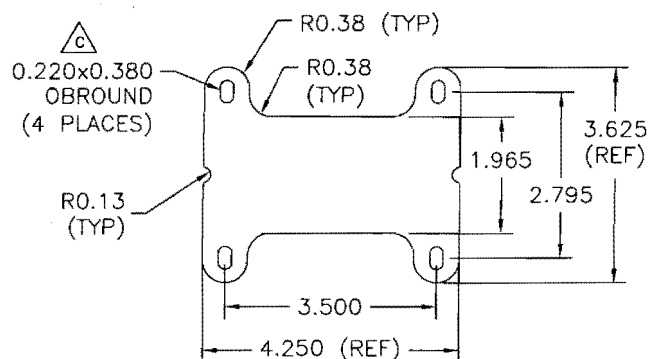
116623

222.28

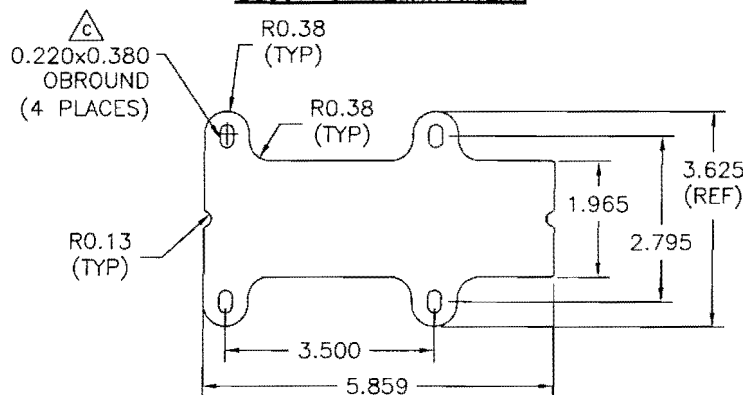
116623

(14)

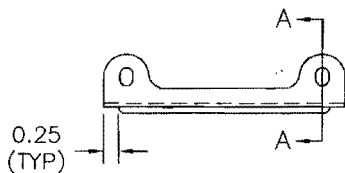
D3537-1F FLAT PATTERN



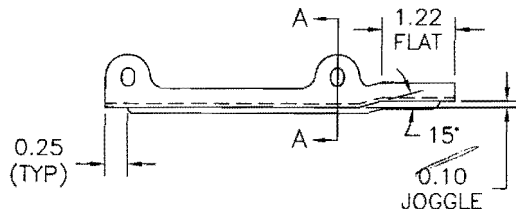
D3537-3F FLAT PATTERN



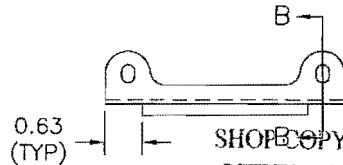
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

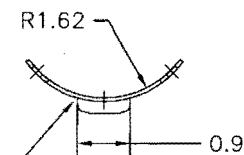


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
C 21102108

D3537-1/-3/-5/-7 WEARPAD NOTES

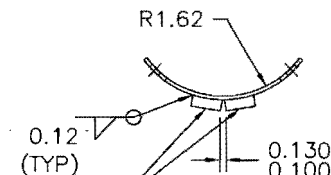
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK) (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



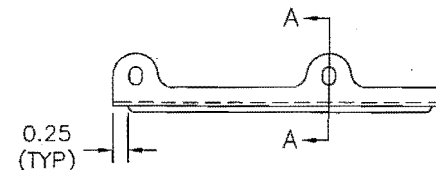
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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DART AEROSPACE USA, INC.

DESIGN	C B	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	DRAWING NO. D3537
DATE	07.04.13	TITLE	WEARPAD	REV. C SHEET 1 OF 1 SCALE 1:2

RELEASED
07.05.08 PH
FOR ELN
962